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IS 5362 (1969): Twist Drills, Parallel Shanks, Stub Series, Left Hand Cutting for Automatics [PGD 32: Cutting tools]

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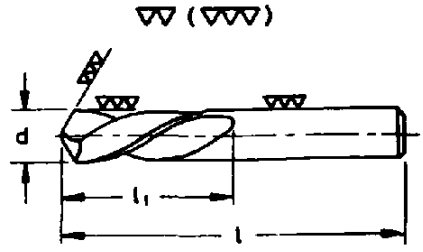
Indian Standard

SPECIFICATION FOR TWIST DRILLS, PARALLEL SHANKS, STUB SERIES, LEFT HAND CUTTING FOR AUTOMATICS

Small Tools Sectional Committee, EDC 45; Twist Drills, Reamers, Tapers, Sockets, Sleeves, Adapters Subcommittee, EDC 45 : 1 [Ref : Doc : EDC 45(1495)]

1. Scope — Dimensions and requirements for twist drills, parallel shanks of stub series for left hand cutting for use with automatics.

2. Dimensions



All dimensions in millimetres.

d* h8	Range of Diameters d		l_1	l
	Over	Up to and including		
1·0	0·95	1·06	6	26
1·1	1·06	1·18	7	28
1·2 1·3	1·18	1·32	8	30
1·4 1·5	1·32	1·50	9	32
1·6 1·7	1·50	1·70	10	34
1·8 1·9	1·70	1·90	11	36
2·0 2·1	1·90	2·12	12	38
2·2 2·3	2·12	2·36	13	40
2·4 2·5 2·6	2·36	2·65	14	43
2·7 2·8 2·9 3·0	2·65	3·00	16	46
3·1 3·2 3·3	3·00	3·35	18	49
3·4 3·5 3·6 3·7	3·35	3·75	20	52
3·8 3·9 4·0 4·1 4·2	3·75	4·25	22	55
4·3 4·4 4·5 4·6 4·7	4·25	4·75	24	58
4·8 4·9 5·0 5·1 5·2 5·3	4·75	5·30	26	62
5·4 5·5 5·6 5·7 5·8 5·9 6·0	5·30	6·00	28	66
6·1 6·2 6·3 6·4 6·5 6·6 6·7	6·00	6·70	31	70
6·8 6·9 7·0 7·1 7·2 7·3 7·4 7·5	6·70	7·50	34	74

*Preferred diameters.

(Continued)

BUREAU OF INDIAN STANDARDS
MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG
NEW DELHI 110002

(All dimensions in millimetres)

d* h8	Range of Diameters d		l_1	l
	Over	Up to and including		
7·6 7·7 7·8 7·9 8·0 8·1 8·2 8·3 8·4 8·5	7·50	8·50	37	79
8·6 8·7 8·8 8·9 9·0 9·1 9·2 9·3 9·4 9·5	8·50	9·50	40	84
9·6 9·7 9·8 9·9 10·0 10·2 10·5	9·50	10·60	43	89
10·80 11·00 11·20 11·50 11·80	10·60	11·80	47	95
12·00 12·20 12·50 12·80 13·00 13·20	11·80	13·20	51	102
13·50 13·80 14·00	13·20	14·00	54	107
14·20 14·50 14·70 15·00	14·00	15·00	56	111
15·20 15·50 15·70 16·00	15·00	16·00	58	116
16·20 16·50 16·70 17·00	16·00	17·00	60	119
17·20 17·50 17·70 18·00	17·00	18·00	62	123
18·20 18·50 18·80 19·00	18·00	19·00	64	127
19·20 19·50 19·80 20·00	19·00	20·00	66	132
20·25 20·50 20·75 21·00	20·00	21·00	68	136
21·25 21·50 21·75 22·00 22·25	21·20	22·40	70	141
22·50 22·75 23·00 23·25 23·50	22·40	23·60	72	146
23·75 24·00 24·25 24·50 24·75 25·00	23·60	25·00	75	151
25·25 25·50 25·75 26·00 26·25 26·50	25·00	26·50	78	156
26·75 27·00 27·25 27·50 27·75 28·00	26·50	28·00	81	162
28·25 28·50 28·75 29·00 29·25 29·50 29·75 30·00	28·00	30·00	84	168
30·25 30·50 30·75 31·00 31·25 31·50	30·00	31·50	87	174
31·75 32·00 32·50 33·00 33·50	31·50	33·50	90	180
34·00 34·50 35·00 35·50	33·50	35·50	93	186
36·00 36·50 37·00 37·50	35·50	37·50	96	192
38·00 38·50 39·00 39·50 40·00	37·50	40·00	100	200

NOTE.—The figure is indicative of dimensions only and does not specify design features, equipment or materials.

3. Designation — A stub series twist drill having 5·00 mm diameter of 'tool-type' N, conforming to this standard and made from high speed steel (HS) shall be designated as:

Twist Drill 5·00 L IS : 5362 HS.

3.1 When required with 'tool-type' other than *N*, an appropriate tool-type shall be mentioned in designation after size.

4. Tolerances — The flute length l_1 and overall length l may vary between the corresponding lengths specified for the preceding and the following range of diameters d.

5. General Requirements

5.1 'Tool-type', unless otherwise specified: *N* according to IS : 5099-1969*.

5.2 *Other Requirements* — According to IS : 5099-1969*.

6. Tests — According to IS : 5099-1969*.

*Technical supply conditions for twist drills.

Reprography Unit, BIS, New Delhi, India

AMENDMENT NO. 1 DECEMBER 1996
TO
IS 5362 : 1969 SPECIFICATION FOR TWIST DRILLS, PARALLEL SHANKS, STUB SERIES, LEFT HAND CUTTING FOR AUTOMATICS

(*Page* 3, *clause* 4) — *Insert* the following notes at the end of clause:

'NOTES

1 In case of range of diameters over 0.95 to 1.06 mm, the tolerance on 'h' shall be ± 1 mm and the tolerance on 'l' shall be ± 2 mm.

2 In case of range of diameters over 37.5 to 40 mm, the tolerance on 'h' shall be ± 4 mm and the tolerance on 'l' shall be ± 7 mm.'

(*Page* 3, *clauses* 5.1, 5.2 *and* 6) — Substitute 'IS 5099 : 1983' *for* 'IS 5099 : 1969'.

(PE 10)

Reprography Unit, BIS, New Delhi, India